

Work Order ID 56903

March 12, 2010 1:25:53 PM

Page 1

Item ID: D3785-3

Accept

Revision ID:

Item Name: Bracket

Setup Start

Stop

Start Date: 12/03/2010 Start Qty: 10.00

Required Date: 26/03/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *10-3-12* Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw'
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3785

RevD

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3785

Dwg Rev: *D*Prog Rev: *D*

****grain direction 45 degree****

2- Deburr if necessary

*B 10-3-16**(D)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-3-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56903

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/03/17



Pb ->

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3785

8/10/03/17

10

P10

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10

7/10/03-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/3/17	#170	Took Qty +1 For inspection template	S	10/03/17	4	<i>[Signature]</i>	S 10/03/17
							1

Part No: D3785-3 PAR #: 10-011 Fault Category: Eng-drawing ~~Small fab~~ NCR: Yes No DQA: [Signature] Date: 10/03/17
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/03/24

NCR: 56903		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/17	130	1 part crack led to change Radius 170 to .388 radius die. RC: Rad was not specified correctly on Dwg. For this Bend RC: Eng drawing.	<i>[Signature]</i> 10.03.17 GS1042	Scrap + destroy no replace Qty +1	<i>[Signature]</i> 10/01/17	<i>[Signature]</i> 10/03-17	<i>[Signature]</i> 10.03.17 GS1042	S 10/03/17
			<i>[Signature]</i> 10/03-17	- open a PAR to ADD correct Rad for this operation	<i>[Signature]</i> 10/03/17	N/A	<i>[Signature]</i> 10/03-17	S 10/03/17

NOTE: Date & initial all entries

Work Order ID 56903

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Item ID: D3785-3

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Setup Start



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Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-counter sink holes as per dwg D3785								
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
170 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

GP 10/03/18 (10)

S 10/02/18

(X 10)

JS 10/03/19

(X 10) 0

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Subs/19

(X10)

Memo

190



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

0.00

W 10/03/22

(X10)

Memo

START TIME: 7:30AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:00AM

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Rec'd 3/22 (10)

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: 88

0.00



Packaging

Memo

0.00

Packaging

(10/10) 3/22 (10)

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24

RP 10-322 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

March 12, 2010 1:26:11 PM

Page 1

Work Order ID: 56903

Parent Item: D3785-3

Parent Item Name: Bracket

Comments: IPP Rev:A 08-05-01 new issue DD verified by:EC
IPP Rev:B 09-01-09 rev.B as per dwg DD verified by:ec

Start Date: 12/03/2010

Required Date: 26/03/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	111.7997	3.1389	3.8		



6061-T6 .080 Sheet



B10-3-16

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	111.79967	
110630	35.0136	
112141	0.86727	
112763	0.19	
113438	75.7288	

113438

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56903
Description: Bracket		Part Number:	D3785-3
Inspection Dwg: D3785 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.006	✓			
6.750	+/-0.010	6.755	✓			
8.500	+/-0.010	8.505	✓			
9.927	+/-0.010	9.930	✓			
0.203	+/-0.010	.206	✓			
0.405	+/-0.010	.409	✓			
5.500	+/-0.010	5.500	✓			
1.500	+/-0.010	1.500	✓			
3.51	+/-0.030	3.509	✓			
3.134	+/-0.010	3.134	✓			
2.259	+/-0.010	2.259	✓			
1.435	+/-0.010	1.434	✓			
1.255	+/-0.010	1.256	✓			
1.427	+/-0.010	1.429	✓			
Ø0.391	+0.006/-0.001	.392	✓			
Ø0.201	+0.005/-0.001	.204	✓			
0.080	+/-0.010	.077	✓			

Measured by:	IB
Date:	10-3-16

Audited by:	S
Date:	10/03/17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	10.02.02	Dimensions revised per Dwg Rev D	KJ	

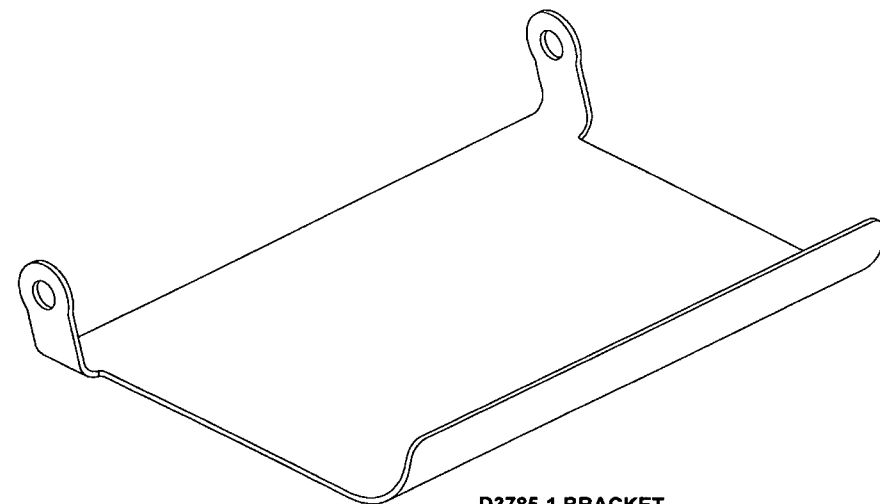
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

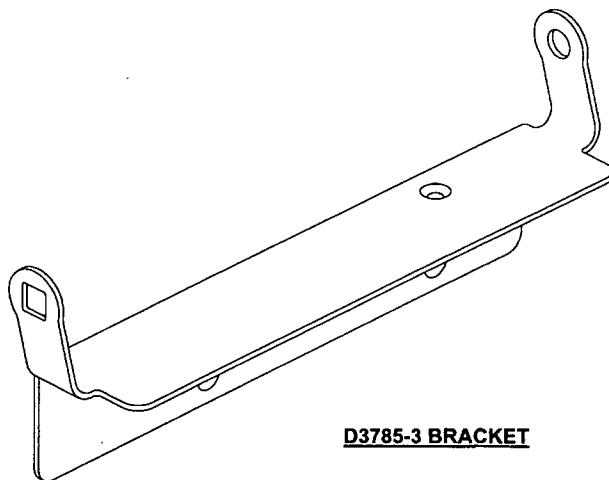
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3785-1 BRACKET



D3785-3 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56903

Bf 10-3-12

RELEASED
2009-12-02
WP

D	REVISED D3785-3 AS FOLLOWS: 1.13 WAS 1.05 (ZN C2-3); 1.500 WAS 2.000 (ZN B7-3); 5.500 WAS 8.750 (ZN B5-3); REASON: PROVIDE MORE CLEARANCE FOR CUSHION UPON ASSEMBLY AND HOLE PATTERN NOT MATCHING D3781-1 HOLE PATTERN.	MB	09.11.26
C	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.07
B	REDESIGNED D3785-3; REMOVED P/Ns D3785-041/-1/-5/-7; DRAWING TITLE WAS ARMREST WELDMENT; REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3785 BRACKET <small>REV. D SHEET 1 OF 3 SCALE NTS</small>	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.11.26	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Dart Aerospace Ltd

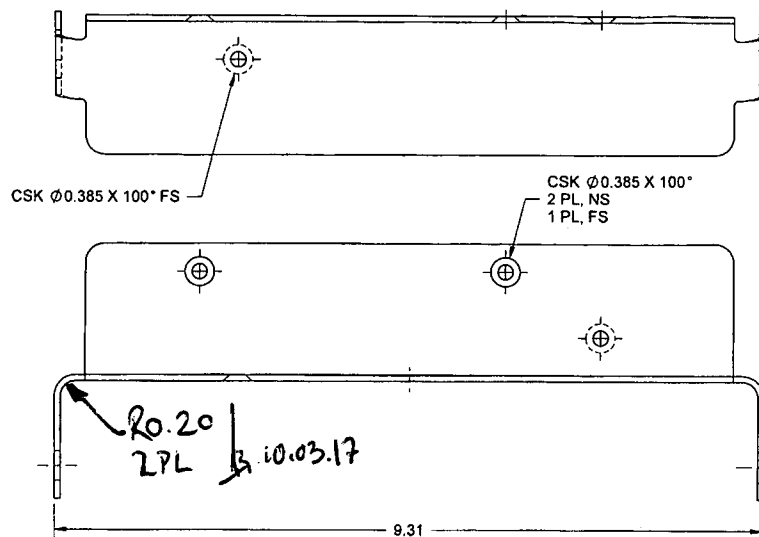
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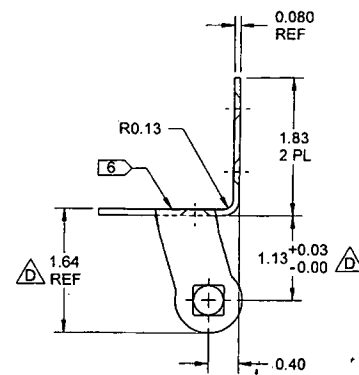
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D3785-3 BRACKET
MAKE FROM D3785-3F



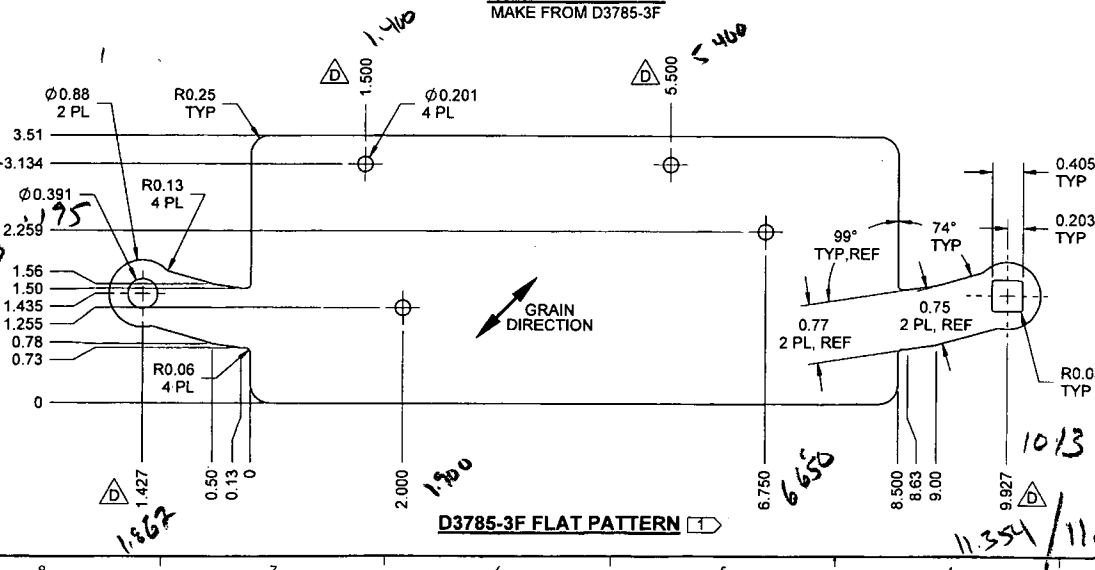
RELEASED
2009-12-02

D3785-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3785	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.11.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

D3785-3F FLAT PATTERN



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